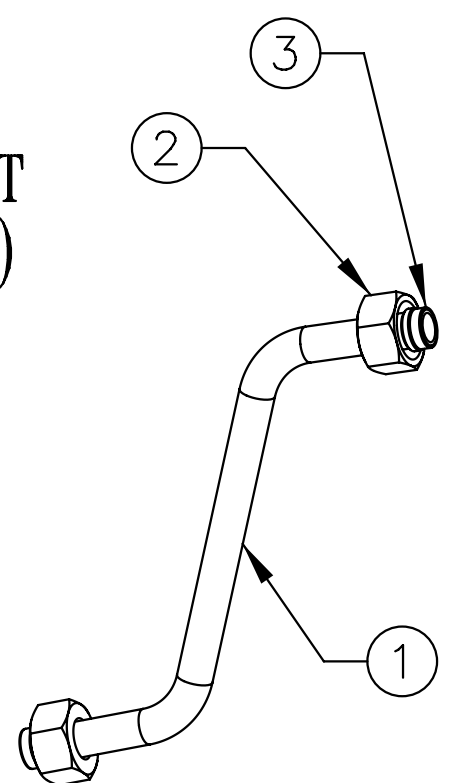




1. MATERIAL: CEW-1 ANNELED TUBE $\phi 16 \times 1.5 \text{ mm}$ THICK AS PER IS-3074.
2. ALL BEND RADIUS = $2 \times \text{O.D.}$
3. TOTAL NO OF BENDS = 2
4. DEVELOPED LENGTH = 325 mm (REF)
5. PIPE SHOULD BE PRIMED AS PER PS-529 PROCEDURE-2 ON OD EXCEPT NUT AND FERRULE.
6. OPERATING PRESSURE IS 30 bar.
7. PIPE SHOULD BE FREE FROM BURRS, CRACKS, DENTS AND ANY FOREIGN PARTICALS INSIDE THE PIPE.
8. MILIPORE VALUE SHOULD BE 8 mg. MAX (FOR INTERNAL SURFACE)
9. PIPE ASSEMBLY SHOULD SUPPLY WITH PLASTIC CAPS AT ENDS.
10. PIPE SHOULD BE TESTED FOR AIR LEAKAGE AT 5 Kg/cm²
11. CRIMP FERRULE UNIFORMLY ALONG SURFACE, MAINTAIN DISTANCE BETWEEN FERRULE CRIMPED END & PIPE END $3 \pm 0.5 \text{ mm}$.
12. TUBE ENDS AND CENTRELIN BEND INTERSECTIONS TO BE WITHIN A TOLERANCE OF $\pm 3 \text{ mm}$

3	007205109B1	FERRULE FOR DIA 16 PIPE	2
2	007205591B1	NUT FOR DIA 16 PIPE	2
1	-	PIPE	1
NO	PART NO.	DESCRIPTION	QTY.

BEND	CO-ORDINATES		
	X	Y	Z
START	0	0	0
A	0	-77	-3
B	-155	-159	2
END	-152	-238	-3

600000 004595	AC			PRODUCTION RELEASE	KB	JV	DVR	7/1/11	
13P015469	AB			L2 DRAWING RELEASE	SG	JV	DVR	18/02/11	
ECN12P014824	AA	AA		L1 DRAWING RELEASE	RSK	RSK	DVR	5/11/11	
E.R.NO.	LET	L0C		REVISIONS	DSNR	CKR.	APPR.	DATE	

<SC> :SIGNIFICANT CHARACTERISTICS										▽:CRITICAL CHARACTERISTICS												
BREAK SHARP CORNERS MAY BE EITHER A CHAMFER OR A RADIUS FROM 0.2 mm MIN. TO 1.0 mm MAX.										MAHINDRA & MAHINDRA LIMITED												
UNSPECIFIED TOLERANCES AS PER ISO-2768-1:1989										TRACTOR DIVISION												
DIMENSIONS										KANDIVLI(EAST), MUMBAI 400 101, INDIA.												
LINEAR IN mm.		OVER UPTO	0.5 3	3 6	6 30	30 120	120 400	400 1000	1000 2000	E.R. / PROC.REQ.NO :					PART NO. :							
										600000004595					E007207222D91							
f FINE (X.XXX)		±0.05		±0.05		±0.1		±0.15		±0.2		±0.3		±0.5		PART NAME :						
m MEDIUM (X.XX)		±0.1		±0.1		±0.2		±0.3		±0.5		±0.8		±1.2		±2		RETURN LINE PIPE 1				
c COARSE (X.X)		±0.2		±0.3		±0.5		±0.8		±1.2		±2		±3		±4		MATERIAL :				
v VERY COARSE(X)		-		±0.5		±1		±1.5		±2.5		±4		±6		±8		HEAT TREATMENT :				
ANGULAR IN deg.		OVER UPTO		-		10		50		120		400		400		-		SEE NOTES				
f FINE (X.XXX)		±1°		±0°30'		±0°20'		±0°10'		±0°5'		±0°5'		±0°5'		±0°5'		CAD ENGG.				
m MEDIUM (X.XX)		±1°30'		±1°		±0°30'		±0°15'		±0°10'		±0°10'		±0°10'		±0°10'		DESIGNER				
c COARSE (X.X)		±1°30'		±1°		±0°30'		±0°15'		±0°10'		±0°10'		±0°10'		±0°10'		CHECKER				
v VERY COARSE(X)		±3°		±2°		±1°		±0°30'		±0°20'		±0°20'		±0°20'		±0°20'		APPR.BY				
PART OF THIS DRAWING / DOCUMENT SHOULD NOT BE REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION OF M & M LTD.										FIRST USED TRCR. MODEL												
COMPUTER GENERATED DRAWING/ DO NOT CHANGE MANUALLY										9500												
IF IN DOUBT, ASK										SCALE NTS												
DO NOT SCALE										SHEET 1 OF 1												
DRG SIZE :A3										UNIT QTY. : 1												
ALL DIMENSIONS ARE IN mm.										WEIGHT : 0.2 kg.												
CHECK DRG WITH LATEST CHANGE																						